



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-541
Job Sheet 203169



Part No: D206-642-541

Job Qty: 1 pcs

Part Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/11/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 12/6/19

Description:

Note: DWG D3274-041 REV G IPP Rev:F 08-06-02 add comment DD verified by:EC IPP Rev:G 08-10-09 revise details DD verified by:EC IPP Rev:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I 14.04.28 AS PER ECN14-520 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	Skidtubes - 1	1 pcs		12/6/19	0.00	3.50	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
114	QC 5	1 pcs		12/6/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
116	QC 10	1 pcs		12/6/19	0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		



Container No: S234821



Part: D206-642-541

Job No: 203169

Serial No/Batch: S234821

Revision: G

Inspector:

Exp Date:

Instructions: FAA STC SAA0475SE 18/10/17, TC STC SH98-

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120 Handfinish - 1-1 Chemical-B4B	1	12/6/19	0.00 0.68	QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130 QC 7	1	12/6/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	

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BEB 19-11-5-00

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						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
						QC 7 - 76	
						QC 7 - 79	
150 Skidtubes - 2 - B4B	1	pcs	12/6/19	0.00	1.50	Skidtubes - 1 - B4B	
						Skidtubes - 2 - B4B	
						Skidtubes - 3 - B4B	mba
						Skidtubes - 4 - B4B	
						Skidtubes - 5 - B4B	
						Skidtubes - 6 - B4B	
						Skidtubes - 7 - B4B	
160 QC 5	1	pcs	12/6/19	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	BE
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
170 Skidtubes - 3 - B4B	1	pcs	12/6/19	0.00	2.17	Skidtubes - 1 - B4B	
						Skidtubes - 2 - B4B	
						Skidtubes - 3 - B4B	mba mba
						Skidtubes - 4 - B4B	
						Skidtubes - 5 - B4B	
						Skidtubes - 6 - B4B	
						Skidtubes - 7 - B4B	
180 QC 5	1	pcs	12/6/19	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	BE
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	

190 Skidtubes - 4 - B4B	1 pcs	12/6/19	0.00 3.68	QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	BE
200 QC 5	1 pcs	12/6/19	0.00 0.00	Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS DEC 04 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
210 QC 10	1 pcs	12/6/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	DAS DEC 04 2019 68
220 Handfinish - 2-1 Pressure- B4B	1 pcs	12/6/19	0.00 0.45	Handfinish - 2 - 1 - B4B	9-89
				Handfinish - 2 - 2 - B4B	DEC 04 2019
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	DAS
230 Spray Paint - 2 - B4B	1 pcs	12/6/19	0.00 0.40	Spray Paint - 1 - B4B	41 DEC 06 2019
				Spray Paint - 2 - B4B	9-89
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
240 QC 14	1 pcs	12/6/19	0.00 0.00	QC 14 - 15	ML 14-12-9
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	

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244 Handfinish - 3-1- WingWalk- B4B	1 pcs	12/6/19	0.00 0.50	QC 14 - 81	
				Handfinish - 3 - 1 - B4B	ML 19-12-9
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
246 QC 3	1 pcs	12/6/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	BEB 19-12-09
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
250 Handfinish - 4-1-Assembly- B4B	1 pcs	12/6/19	0.00 0.45	Handfinish - 4 - 1 - B4B	ML 19-12-9
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
260 QC 5	1 pcs	12/6/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	

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						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	DAS DEC 09 2019 40 9-89
						QC 5 - 61	
						QC 5 - 81	
						Handfinish - 4 - 1 - B4B	20 14-12-9
270 Handfinish - 4-2-Assembly-B4B	1 pcs	12/6/19	0.00	0.68		Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
280 QC 5	1 pcs	12/6/19	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	DAS DEC 17 2019 68 9-89
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
290 Packaging 3-1 - Stock - B4B	1 pcs	12/6/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
295 DC - 1 - B4B	1	12/6/19	0.00 0.00	DC - 1 - B4B	
	pcs			DC - 2 - B4B	
300 QC 21 - FG	1	12/6/19	0.00 0.00	QC 21 - FG - 21	
	pcs			QC 21 - FG - 70	
				QC 21 - FG - 53	

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Part Op 110 - (Skid tubes) *****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE***** 1- remove fwd indexing ridge as per Descriptions: dwg D3274. Prepare for welding 2- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: 130989/13909 3- grind fwd cap weld on top surface only 4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end. 5-Drill Aft cap pilot hole using DT8025 6 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274 7 -Remove inner indexing ridge on aft end of skid tube as per Dwg D3274 scribe batch # 8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

114 - (QC5- Inspect part completeness to step on W/O)
 116 - (QC10- Inspect visual per QSI004- ground welds)
 120 - (Chemical Conversion Coat per QSI005 4.1)
 130 - (QC7-Inspect Chemical Conversion Coat)
 150 - (Skid tubes) 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube 3-Bond web in place as per Dwg D3274 & QSI 015. (Adhere for 12 hours) S 231095 ex 103-18-2020
 160 - (QC5- Inspect part completeness to step on W/O)
 170 - (Skid tubes) 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding

180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Skid tubes) 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod 3-Grind cross bolt welds flush as per Dwg D3274. *****INSPECT FOR PIN HOLES IN WELD***** 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

200 - (QC5- Inspect part completeness to step on W/O)
 210 - (QC10- Inspect visual per QSI004- ground welds)
 220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch
 230 - (Spray Paint / NDT Room) Make sure Nut Plate Thread is protected using paint screw. 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5218188 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5231052
 240 - (QC14- Inspect Spray Paint)
 244 - (Wing Walk as per dwg QSI005 4.4 Batch 5209896)
 246 - (QC3- Inspect Part Finish)
 250 - (Assemble as per dwg) 1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.
 260 - (QC5- Inspect part completeness to step on W/O) Inspect Nut Plate & Inserts

270 - (Assemble as per dwg) 1-Install wearpads as per Dwg D3274. 2-Install ring as per Dwg D3274 3-Inspect for foreign objects as per QSI 024 4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

280 - (QC5- Inspect part completeness to step on W/O)

290 - (Identify as per dwg & Stock Location: _____) Location : FG073

295 - (Document Control) Photocopy bluefile & type labels per PPP D206-642- 541 CHG005

300 - (QC21- Final Inspection - Work Order Release) 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 using DT10280 and deburr.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3274-041BENT	Skidtube Assembly 206	1 pcs (1 ea)	110-Skidtubes - 1	013325 5216847
D3285-1	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5233265
D3282-041	Float Web (206L/407)	1 pcs (1 ea)	150-Skidtubes - 2 - B4B	5219825
D2649	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5233402
D3275-1	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5213175
ALS4-1032-130	Rivnut	78 Ea (78 ea)	250-Handfinish - 4-1-Assembly-B4B	9057258-1
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5226101
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5163730-3
D3415-041	Nut Plate	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5218086
AN3C4A	Bolt	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5220803-1
AN4C5A	Bolt	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5225261
D2646	Aft Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5197616
D3413-1	O-Ring	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5276755-2
D3537-1	Wearpad	9 pcs (9 ea)	270-Handfinish - 4-2-Assembly-B4B	5229957
D3537-3	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5218982
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	5164008
D4956-15	Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5218063
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5232173
D4956-35	Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5236386
D4956-39	Wearplate Center Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5219202
NAS1149C0332R	Washer (AN960C10L)	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5233309
NAS1149C0463R	Washer (AN960C416)	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5104377

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D3274-041BENT	1	8	0
	D3285-1	1	0	0
150-Skidtubes - 2 - B4B	D3282-041	1	4	0
190-Skidtubes - 4 - B4B	D2649	12	93	0
	D3275-1	12	218	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	78	4,866	0
	CCR264SS3-3	2	101	0
	CR3212-4-03	2	128	0
	D3415-041	1	43	0
270-Handfinish - 4-2-Assembly-B4B	AN3C4A	80	1,630	0
	AN4C5A	1	82	0
	D2646	1	29	0
	D3413-1	1	29	0
	D3537-1	9	74	0
	D3537-3	1	19	0
	D3672-1	2	1,195	0
	D4956-15	1	17	0
	D4956-23	1	4	0
	D4956-35	1	8	0
	D4956-39	1	14	0
	NAS1149C0332R	80	3,894	0
	NAS1149C0463R	1	151	0

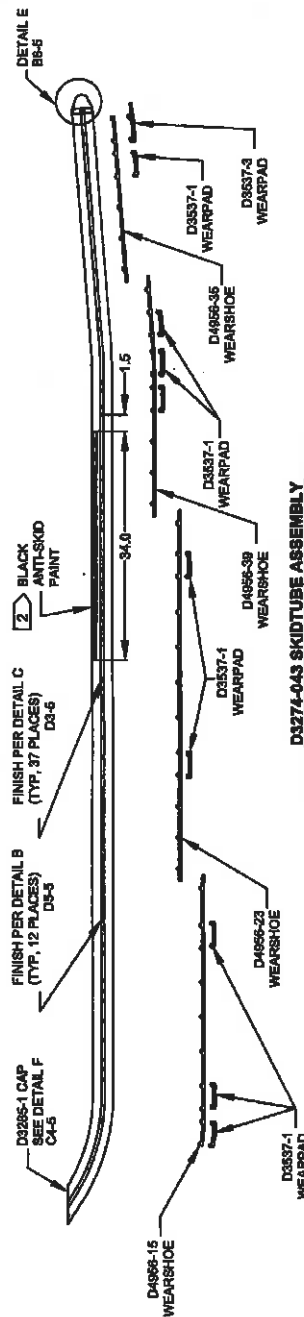
Part Specifications

Specifications could not be found.

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D3274-043 DRILLING/ASSEMBLY DETAIL

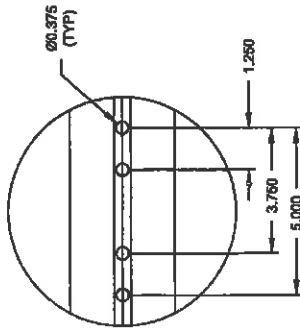
D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

DESIGN	CP	DART AEROSPACE USA, INC ELIZABETH, OR DRAWING NO. REV. 9 D3274 SHEET 3 OF 6 TITLE SKIDTUBE ASSEMBLY SCALE NTS COPYRIGHT © 1984 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED TO THE PUBLIC UNLESS SO INDICATED BY A DART AEROSPACE USA, INC.
DRAWN	RF	
CHECKED	AK	
MFG. APPR.	JLM	
APPROVED	DS	
DES. APPR.	1	
DATE	16.04.25	

DETAIL A: DRILL DETAIL
D4-2, D3-2, D4-3, D3-3

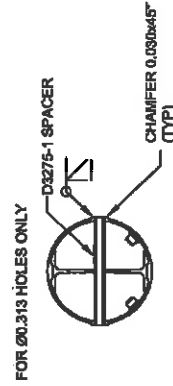


DETAIL B
B4-2, B4-3



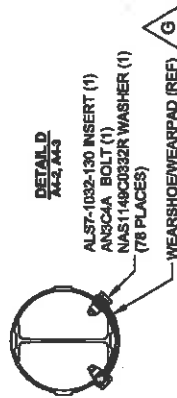
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2648 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C
B4-2, B4-3



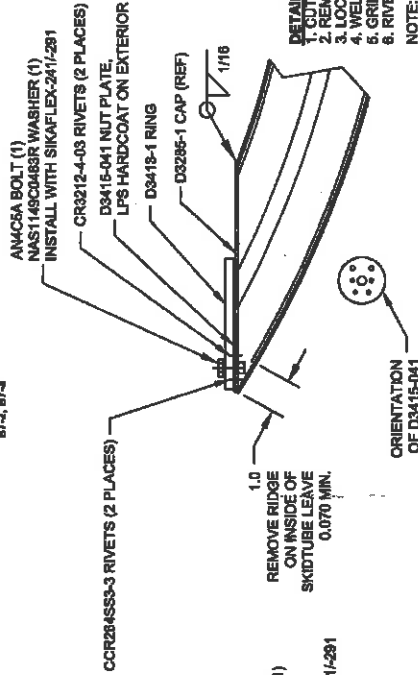
FOR Ø0.313 HOLES ONLY

DETAIL D
A4-2, A4-3



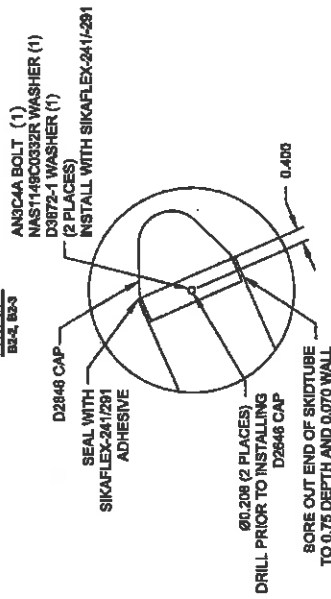
AL57-1032-130 INSERT (1)
AN3C4A BOLT (1)
NAS1148C0332R WASHER (1)
(78 PLACES)
WEARSHOE/WEARPAD (REF)

DETAIL E: END FINISHING DETAIL
B7-4, B7-5



DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3286-1 (TRIM AS NECESSARY)
4. WELD D3286-1 IN PLACE PER DART Q81004
5. GRIND FLUSH
6. RIVET D8415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DETAIL E
B4-2, B4-3



Ø0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2648 CAP
BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

DESIGN	CP	RF	AK	JLM	DS	DE APPR.	DATE	16.04.25	1
DRAWN									
CHECKED									
MFG. APPR.									
APPROVED									
DE APPR.									
TITLE									
SKIDTUBE ASSEMBLY									
SCALE									
NTS									

DART AEROSPACE USA, INC
EUGENE, OR
DRAWING NO. D3274
REV. G
SHEET 5 OF 6
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WWW.DARTAEROSPACE.COM

RELEASED
2016-07-26

-041/-043 DETAILS

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
Date :	Sequence #:	QTY Affected :		MRB (QS1042)																															
Description Work Order Deviation		Disposition																																	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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Other/Details:																																			
		Completed By		Lead hand / Supervisor																															
				QC / QA Coordinator																															